



Dart Aerospace Ltd.
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D2894-1**Job Sheet 210553****Part No:** D2894-1**Job Qty:** 4 pcs**Part Name:** 2.75 Support**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/12/20**Job Tracking No:****Due Date:** 7/10/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:** SIOP

Note: DWG REV E IPP: B 02.11.26 Added mask hole KJ IPP Rev:C ECN 993 07-11-07 DD verified by:EC IPP D
08.03.19 Re-format EC verified by DD IPP REV:E 11.10.03 ASPER REV:C DD VERF:EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	4 pcs	7/10/20		0.79	9.85	HAAS - 1		J.C. 20-07-13
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
120	QC 8	4 pcs	7/10/20		0.00	0.00	QC 8 - 12		J.C. 20-07-17
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		



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Container No: S287300**Part:** D2894-1**Job No:** 210553**Serial No/Batch:** S287300**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Date: 07/12/20

Plex 6/12/20 10:06 AM Dart.lajeunesse.marie

130 Packaging 3-1 - Stock - B4B 4 pcs	7/10/20	0.00 0.00	QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
			Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	
			Packaging 3 - 6 - B4B	
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	DAS JUL 17 2020
			Packaging 3 - 23 - B4B	41
			Packaging 3 - 24 - B4B	9:30
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	
			Packaging 3 - 37 - B4B	DAS
140 QC 21 - SA 4 pcs	7/10/20	0.00 0.00	QC 21 - SA - 21	DAS JUL 17 2020
			QC 21 - SA - 70	21
			QC 21 - SA - 9	9:30

Part Op 100 - (HAAS CNC Vertical Machine) Machine as per Folio FA253 Tumble & Deburr
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____) LOCATION: LG051
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK079	D2894-1 Turning Detail	2 pcs (.5 ea)	100-HAAS 4 Axis	167 965

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-HAAS 4 Axis	DSK079	2	8	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	2.750 Support	0.454Inches	+ 0.020 - 0.000	0.474 0.454	
2	2.750 Support	3.062Inches	+ 0.020 - 0.000	3.082 3.062	
3	2.750 Support	0.053Inches	+ 0.020 - 0.000	0.073 0.053	
4	2.750 Support	1.766Inches	+ 0.020 - 0.000	1.786 1.766	
5	2.750 Support	0.020Inches	+ 0.020 - 0.000	0.040 0.020	
6	2.750 Support	0.260Inches	+ 0.007 - 0.000	0.267 0.260	
7	2.750 Support	0.170Inches	+ 0.020 - 0.000	0.190 0.170	
8	2.750 Support	0.150Inches	+ 0.020 - 0.000	0.170 0.150	
9	2.750 Support	1.970Inches	+ 0.060 - 0.000	2.030 1.970	
10	2.750 Support	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
11	2.750 Support	1.880Inches	+ 0.020 - 0.000	1.900 1.880	
12	2.750 Support	0.500Inches	+ 0.005 - 0.000	0.505 0.500	
13	2.750 Support	0.188Inches	+ 0.006 - 0.000	0.194 0.188	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order:	
Description: Ø2.750 Support		Part Number:	D2894-1
Inspection Dwg: D2894	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
HAAS Section								
AA	0.454	0.474		0.469	0.469	0.469	0.469	
AB	3.062	3.082		3.072	3.072	3.072	3.072	
AC	0.053	0.073		0.063	0.063	0.063	0.063	
AD	1.766	1.786		1.775	1.775	1.775	1.775	
AE	0.020	0.040		0.040	0.040	0.040	0.040	
AF	0.260	0.267		0.262	0.262	0.262	0.262	
AG	0.170	0.190		0.180	0.180	0.180	0.180	
AH	0.150	0.170		0.160	0.160	0.160	0.160	
AI	1.970	2.030		2.000	2.000	2.000	2.000	
AJ	0.240	0.260		0.250	0.250	0.250	0.250	
AK	1.880	1.900		1.890	1.890	1.890	1.890	
AL	0.500	0.505		0.501	0.501	0.501	0.501	
AM	0.188	0.194		0.189	0.189	0.189	0.189	
Ensure that Ø0.500" bore is perpendicular to 1.389" bore within 0.003"								
Accept/Reject								

Measured by: J.C.	Date: 12-07-12
Audited by: DAS	Date: 20-07-17
Preliminary Approval: 20	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	06.03.08	DT8708 added to dimension AM	KJ/JLM	
C	06.11.22	Note added to HAAS section	KJ/JLM	
D	08.04.22	Reformat; Dwg Rev updated	KJ/DD	
E	08.11.25	Dimensions updated per Dwg Rev. D	KJ/JLM	
F	09.05.04	Dimension AN (0.926) removed	KJ/JLM	
G	13.05.22	Dimensions updated per Dwg Rev. E	KJ	